

Date: Tuesday, 27/05/2008 12:37:40 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	INNER AFT SADDLE		
Job Number	39510			Part Number	D5957		
Estimate Number	11082			Drawing Number	D5957 REV B		
P.O. Number	:			Project Number	N/A		
This Issue	27/05/2008	S.O. No.	:	Drawing Revision	B		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	MACHINED PARTS	Due Date	03/06/2008	Qty:	1 Um: Each
Previous Run	39199						
Written By	<u>Linda Lacelle</u>						
Checked & Approved By							
Comment	Est Rev:E	Re-Format	05-11-29 JLM				
	Est Rev:F	ecn826	06.12.06 ec				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) D6101-007(7075-T7351) Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: <u>B34875</u>	<u>8J 08/05/31</u>
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3	
		Comment: HAAS CNC VERTICAL MACHINING #3	
		1-Machine as per folio D5957, Ensure Batch Number is entered	
		2-Machine Keyway	
		3-Deburr & Tumble	<u>8J 08/05/31</u>
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<u>8J 08/05/31</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>JL 08/06/01</u>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<u>1X</u> <u>M-J 12/17</u> <u>08 08/06/02</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: INNER AFT SADDLE

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Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



m107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(P)

START TIME: 1:05

OVEN TEMPERATURE: 320°

FINISH TIME: 1:35

Fd 08/06/02

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(D)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Bk 08-06-02

8.0 PACKAGING 1

PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 421

8/6/2

Sy.

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/03 JF

Comment: FINAL INSPECTION/W/O RELEASE

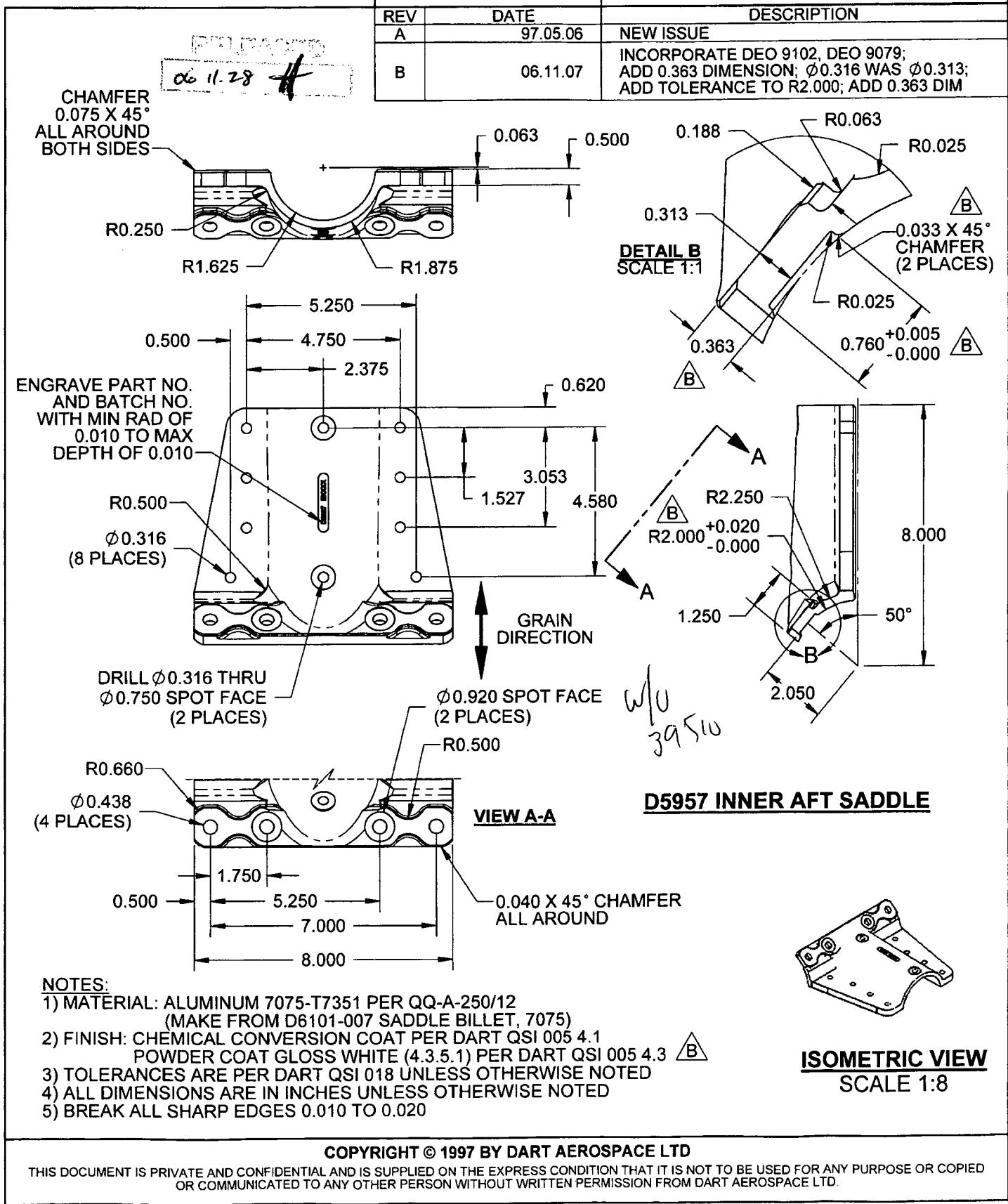
Job Completion



W08/06/03

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D5957	REV. B SHEET 1 OF 1
DATE 06.11.07		TITLE INNER AFT SADDLE	SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
REV B	DATE 06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø 0.316 WAS Ø 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



DART AEROSPACE LTD	Work Order:	39810
Description: Inner Aft Saddle	Part Number:	D5957
Inspection Dwg: D5957	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.442					
B	1.745	1.755		1.750					
C	5.245	5.255		5.250					
D	6.995	7.005		7.000					
E	5.240	5.260		5.250					
F	4.745	4.755		4.750					
G	0.315	0.322		.319					
H	1.522	1.532		1.526					
I	3.048	3.058		3.052					
J	4.575	4.585		4.581					
K	0.313	0.318		.318					
L	0.495	0.505		.501					
M	0.490	0.510		.504					
N	1.865	1.885		1.875					
O	7.990	8.010		7.994					
P	2.240	2.260		2.250					
Q	0.307	0.312		.310					
R	0.760	0.765		.760					
S	0.490	0.510		.494					
T	1.625	1.645		1.632					
U	2.000	2.020		2.004					
V	0.023	0.043		.033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: RF
Date: 08/05/11

Audited by: JL
Date: 08/06/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	